

Work Order ID 123249

September-02-14 1:41:54 PM

123249

Page 1

Item ID: D4866-042 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: 206L AFT Leg Assembly, RH
 Start Date: 8/01/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/05/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4866	C

110 0.00

110

Small Fab
 Small Fab

Memo
 ALIGN PILOT HOLES IN D4866-2 WITH PILOT HOLES IN D4870-1 AND
 D4870-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER
 DWG.
 REAM EACH HOLES USING REAMER, USING DART TOOL SETUP
 DT9963 AS PER DWG.

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC
 Quality Control!

Memo 0.00

DAS
 38
 9-89 14-9-8

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Item ID: D4866-042 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: 206L AFT Leg Assembly, RH
 Start Date: 8/01/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/05/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Small Fab	Memo	0.00							
Small Fab	INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9963 A/R HYSOL BATCH: <u>M 128 774</u>								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Outsource process - Laser Marking	0.00							
150									
Outsource9	Memo	0.00							
Outsource process - Laser Marking	ISSUE P/O: <u>25658</u> OUTSOURCE VENDOR: P&L PRINTING ENGRAVE P# AS PER DWG C OF C IS REQUIRED								

1 FF 14-09-08

1 DAS 38 9-89 14-9-9

CL 14/09/05 2

Work Order ID 123249

123249

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Item ID: D4866-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206L AFT Leg Assembly, RH
 Start Date: 8/01/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/05/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: 81123	0.00							
180									
Packaging	Memo	0.00							
Packaging									

14/9/8 (2)

4 **DAS 38 9-89 14-9-8**

1x 14-9-9 SP

Work Order ID 123249

123249

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September-02-14 1:41:54 PM

Item ID: D4866-042 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: 206L AFT Leg Assembly, RH
 Start Date: 8/01/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/05/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00				ML5		14-09-09	
Quality Control									

MF
14-9-9

Picklist Print

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Page 1

Work Order ID: 123249

123249

Parent Item: D4866-042

D4866-042

Parent Item Name: 206L AFT Leg Assembly, RH

Start Date: 8/01/14

Required Date: 8/05/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.01.14 NEW ISSUE DD VERF:JLM IPP
REV:B 14.07.07 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
HL32PB5-12		Purchased	No				Each	488.0000		4			

HI 32PB5-12

Hi-Lok Pin

**

FF 14-09-08

Location

Loc Qty

Loc Code

ST263

488

M129912

488

4

D4866-2

Manufactured

No

Each

1.0000

1

D4866-2

Strut

**

FF 14-09-08

Location

Loc Qty

Loc Code

ST123

1

123249

1

121252

1

D4870-1

Manufactured

No

Each

5.0000

1

D4870-1

End Fitting, Small

**

FF 14-09-08

Location

Loc Qty

Loc Code

ST124

5

112016

1

116538

4

1

D4870-3

Manufactured

No

Each

4.0000

1

D4870-3

End Fitting, Large

**

FF 14-09-08

Location

Loc Qty

Loc Code

ST124

4

116339

4

1

Picklist Print

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Page 2

Work Order ID: 123249

123249

Parent Item: D4866-042

D4866-042

Parent Item Name: 206L AFT Leg Assembly, RH

Start Date: 8/01/14

Required Date: 8/05/14

Start Qty: 1.00

Required Qty: 1.00

HL86-5

Purchased

No

Each

1,189.000

4

HI 86-5

**

FF 14-09-08

Collar

Location

Loc Qty

Loc Code

ST263

1189

M128110

12

M128228

29

M129022

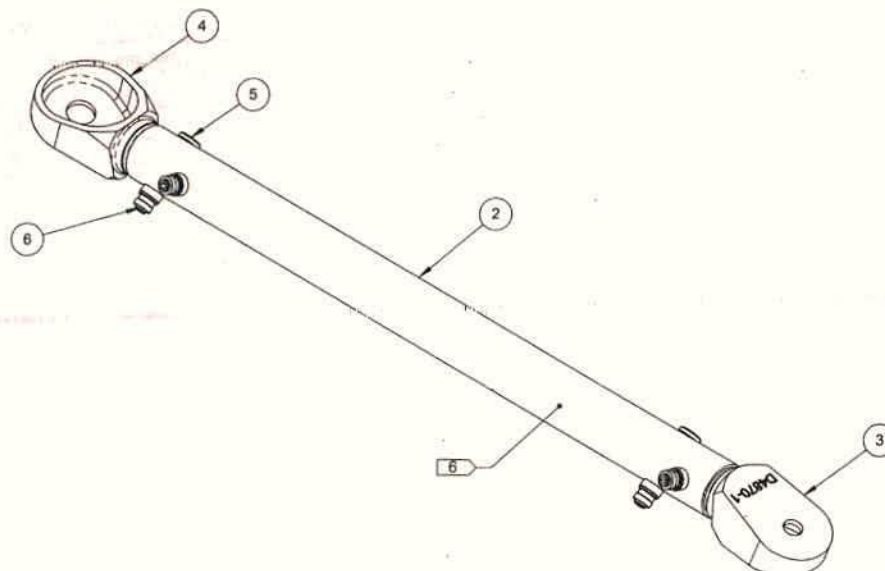
200

M129864

948

4

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D4866-041	AFT LEG ASSEMBLY, LH
2	1	D4866-1	STRUT
3	1	D4870-1	END FITTING, SMALL
4	1	D4870-3	END FITTING, LARGE
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4866-041 AFT LEG ASSEMBLY, LH
(EQUIVALENT TO BELL P/N 206-063-105-001)

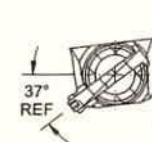
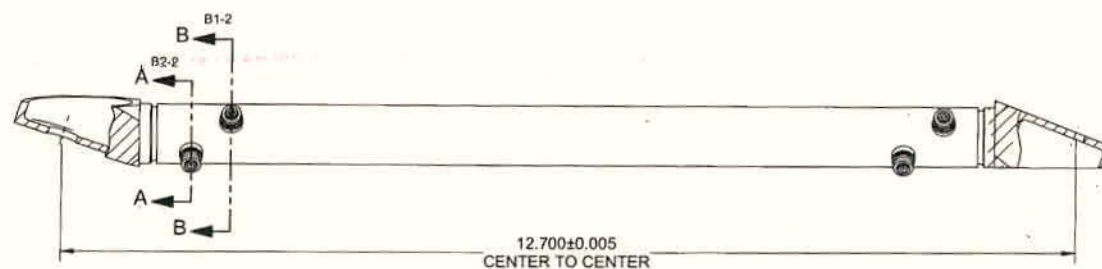
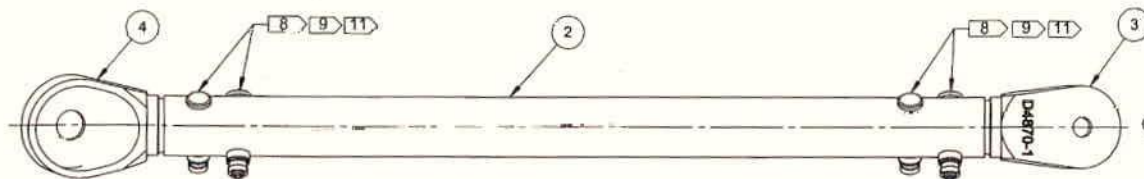
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.76 lbs
- 8) ALIGN PILOT HOLES IN D4866-1 WITH PILOT HOLES IN D4870-1 & D4870-3.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9962
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9962
- 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

RELEASED
2014-07-07

REV.	DESCRIPTION	BY	DATE
C	HL32PB5-12 WAS HI 20PB5-12 (ZN D4-1, D4-3); REVISE NOTE 8) (ZN A5-5, A5-6); REVISED PART DESCRIPTION (ZN B4-1, B4-2, B4-3, B4-4)	RF	14.06.24
B	REVISE NOTES 6) & 9) (ZN A8-1, A8-3); ADDED BELL P/N	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4866	SHEET 1 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
DATE	14.06.24	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

APPROVED



SECTION A-A C7-2
2 PL



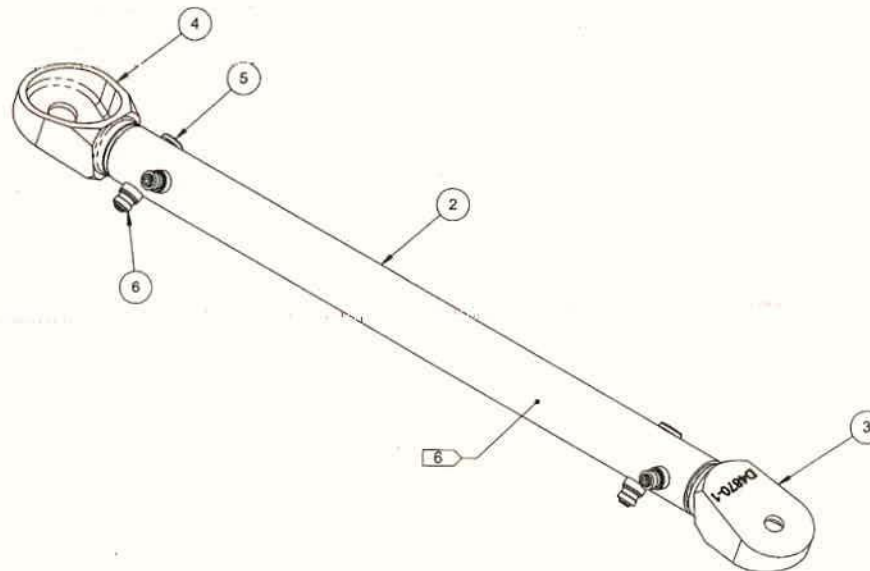
SECTION B-B C7-2
2 PL

D4866-041 AFT LEG ASSEMBLY, LH
AUXILIARY VIEW

RELEASED
2014-07-07
md

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	DRAWN	VS		
	CHECKED	HS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D4866	SHEET 2 OF 6
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	LEG ASSEMBLY	NTS
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ITEM	QTY. -042	P/N	DESCRIPTION
1	X	D4866-042	AFT LEG ASSEMBLY, RH
2	1	D4866-2	STRUT
3	1	D4870-1	END FITTING, SMALL
4	1	D4870-3	END FITTING, LARGE
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4866-042 AFT LEG ASSEMBLY, RH
(EQUIVALENT TO BELL P/N 206-063-105-002)

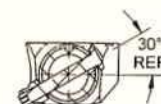
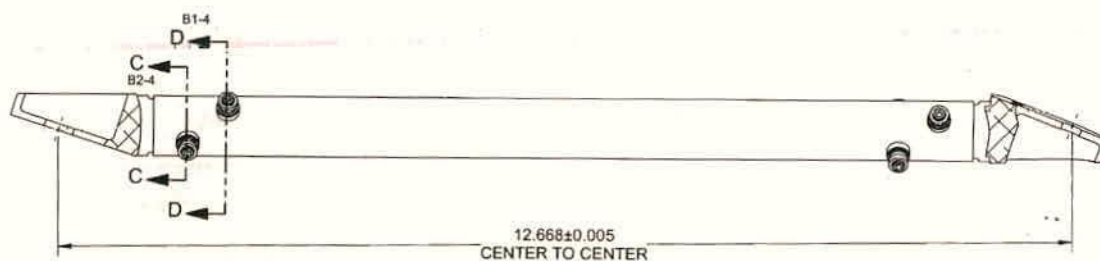
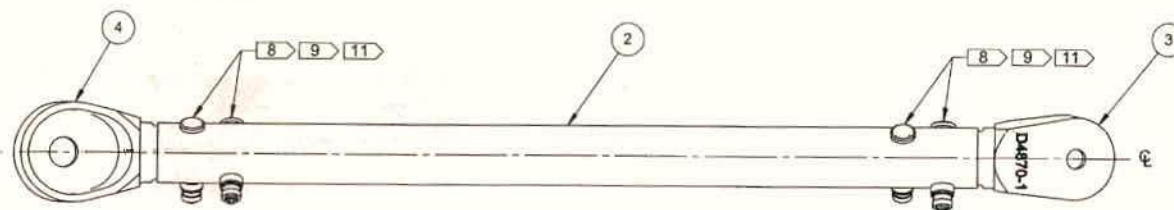
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.76 lbs
- 8) ALIGN PILOT HOLES IN D4866-2 WITH PILOT HOLES IN D4870-1 & D4870-3.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 ($\phi 0.1610$) REAMER, USING DART TOOL SETUP DT9963
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 8398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9963
- 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

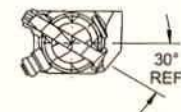
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2014-07-07

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DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4866	SHEET 3 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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SECTION C-C C7-4
2 PL



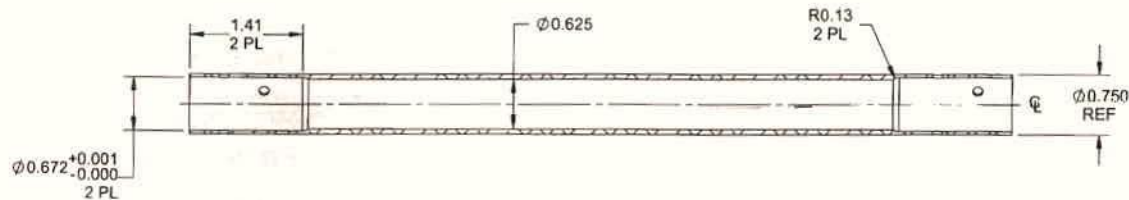
SECTION D-D C7-4
2 PL

D4866-042 AFT LEG ASSEMBLY, RH
AUXILIARY VIEW

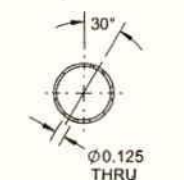
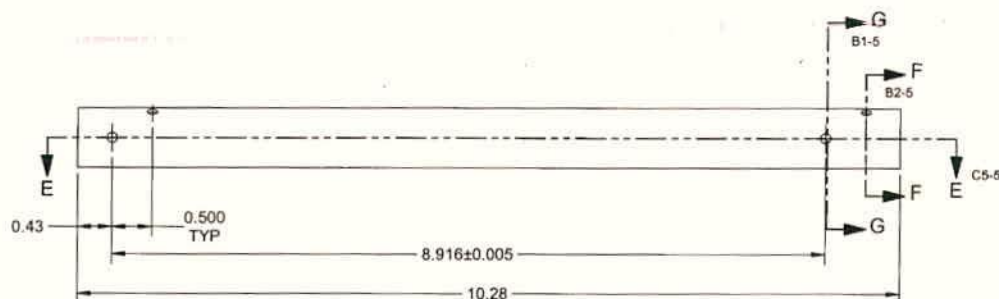
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2014-07-07

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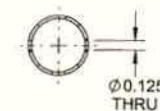
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DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4866	SHEET 4 OF 6
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SECTION E-E B3-5



SECTION F-F C4-5
2 PL



SECTION G-G C4-5
2 PL

D4866-1 STRUT

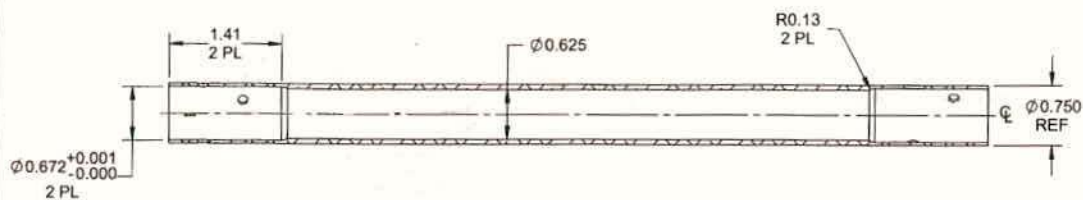
NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 0.36 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

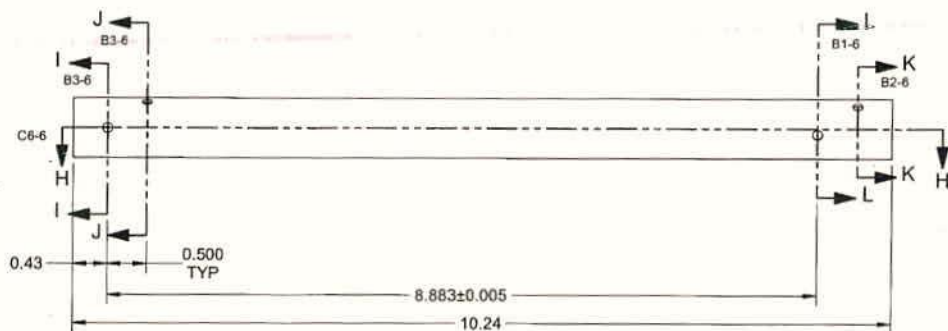
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4866	SHEET 5 OF 6
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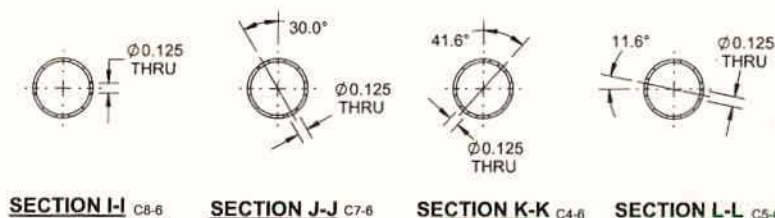
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2014-07-07
MP



SECTION H-H B8-6



D4866-2 STRUT



SECTION I-I C8-6

SECTION J-J C7-6

SECTION K-K C4-6

SECTION L-L C5-6

RELEASED
2014-07-07

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 0.35 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4866	SHEET 6 OF 6
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25658**

Purchase Order Date 9/5/2014

PO Print Date 9/8/2014

Page Number 1 of 2

Order From :

VC-PL001

P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-931-1241

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	123249 LASER MARKED	D4866-042 LEG ASSEMBLY	9/8/2014 Yes 9/8/2014		2.00	\$4.00	\$8.00
						Line Total:	\$8.00
2	121444 LASER MARKED	D4880-042 LEG ASSEMBLY	9/8/2014 Yes 9/8/2014		3.00	\$4.00	\$12.00
						Line Total:	\$12.00
3	121016 LASER MARKED	D4882-041 LEG ASSEMBLY	9/8/2014 Yes 9/8/2014		1.00	\$4.00	\$4.00

Note:

9/8/2014



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE Sept. 6, 2014

P.O NUMBER PO25658

ITEM DESCRIPTION	QUANTITY	COMMENTS
D4866-042 LEG ASSEMBLY	2	ALL ITEMS HAVE BEEN LASER MARKED
D4880-042 LEG ASSEMBLY	3	
D4882-041 LEG ASSEMBLY	1	